

Work Order ID 83825

83825

Thursday, April 26, 2012 1:07:43 PM

ASAP

Page 1

Item ID: D4125-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Sump
 Start Date: 4/26/2012 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 5/3/2012 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: mmf Date: 12-04-26 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4125	C								

100 0.00
 100
 Bandsaw Memo 0.00
 Jeaspa Bandsaw 1-Cut Blank at 13.375" SL 12-04-28 ① 12/05/01 ⑥

105 0.00
 105
 HAAS I Memo 0.00
 HAAS CNC vertical machine #1 Machined as per folio FB078
 Rev: AA
 Dwg: C
 Deburr 6 ① 12/05/02

W/O: 83825

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4125-1 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: OK Date: 12/05/04
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 12/5/7

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/05/01	110	Part moved when center drilling hole R. moved Darrin machine Process / tooling	<u>W</u> 12/05/02	Scrap + Destroy Q421 and Replace B <u>119805</u>	<u>W</u> 12/05/01	<u>W</u> 12/05/02	<u>W</u> 12/05/02	<u>S</u> 12/05/02

NOTE: Date & initial all entries

Thursday, April 26, 2012 1:07:43 PM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 4/26/2012 **Start Qty:** 6.00 ***6***

Cust Item ID:

Required Date: 5/3/2012 Req'd Qty: 6.00 *6*

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool #**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83825

83825

Page 3

Thursday, April 26, 2012 1:07:43 PM

Item ID: D4125-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Sump
 Start Date: 4/26/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 5/3/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00				6x	φ		11/10/07
Quality Control									
150	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
150									
Packaging	Memo	0.00				6x	φ		12.05.02
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							12/5/3φ
Quality Control									

12/05-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 26, 2012 1:07:43 PM

Page 1

Work Order ID: 83825

Parent Item: D4125-1

Parent Item Name: Sump

Start Date: 4/26/2012

Required Date: 5/3/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.07.21 new issue DD verf:EC
IPP Rev:B 11/12/05 as per dwg. rev.B JFS verf:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X08.000 6061-T6 BAR 2.00' X 8.00"		Purchased	No			100	f	16.5094	1.115	7.0421053 8.225			

Location

MAT005

→ 119805

Loc Qty

16.5094

16.5094

Loc Code

21 12-04-28

7.1 + 1.125 12/05/01

8.225'

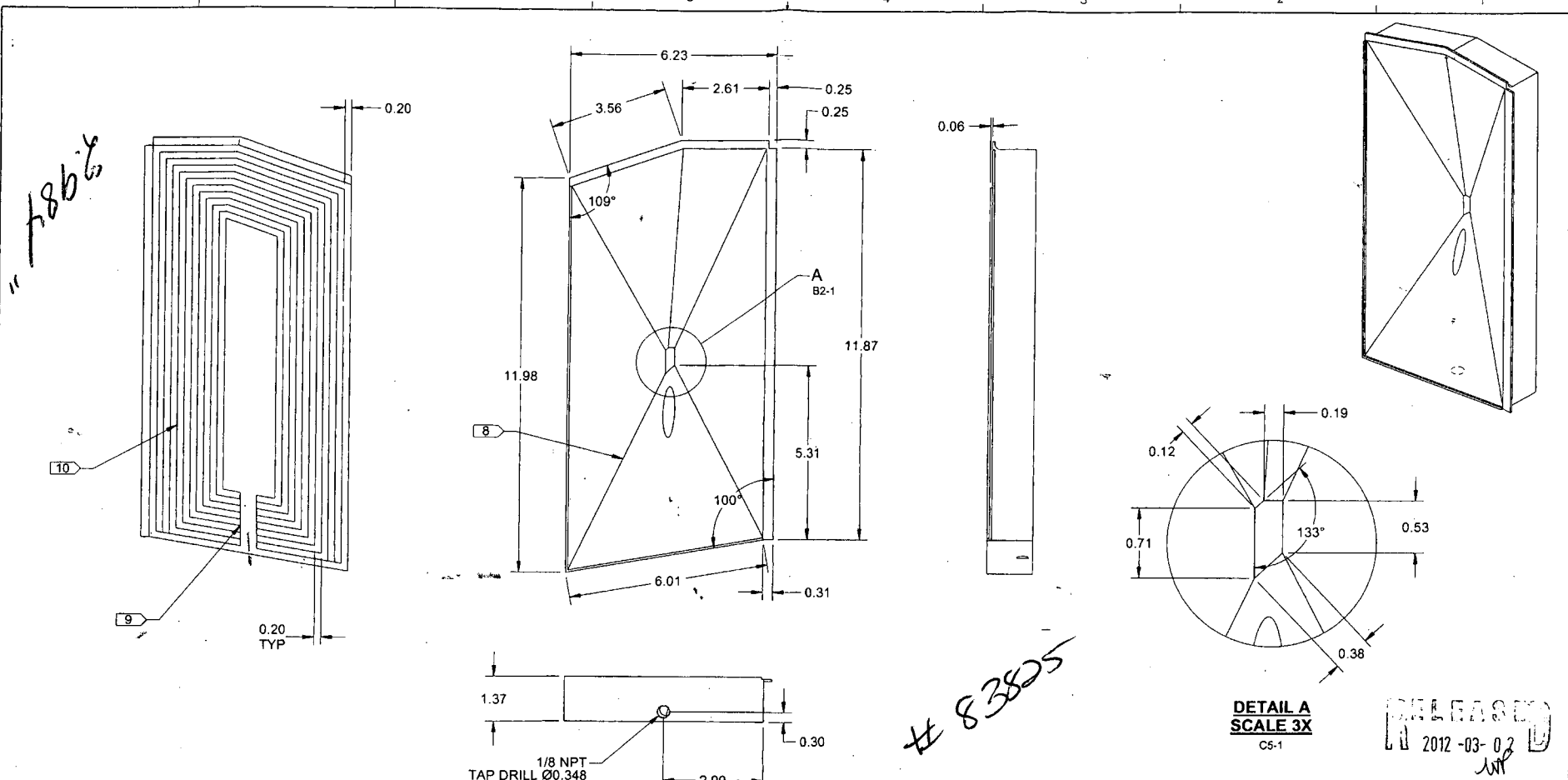
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



83805

DETAIL A
SCALE 3X
C5-1

RELEASED
2012-03-02

- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B1.750X6.250
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 3.26 lbs
 - 8) MAXIMUM INSIDE RADIUS = 0.250
 - 9) MINIMUM RADIUS = 0.187
 - 10) MINIMUM RADIUS = 0.015

D4125-1 FWD SEDIMENT BOWL

C	MODIFY DESIGN OF -1/-3: ADD PERIMETER WALL, CREATE EQUAL STEPS.	DC	11.11.29
B	MODIFY DESIGN OF -1/-3, REMOVED -041	DC	11.09.29
A	NEW ISSUE	HS	10.07.26
REV.	DESCRIPTION	BY	DATE
DESIGN	BC		
DRAWN	BC		
CHECKED	BC		
MFG. APPR.	BC		
APPROVED	BC		
DE APPR.	BC		
DATE	11.11.29		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4125	REV. C
TITLE SEDIMENT BOWLS	SCALE NTS
COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

